Celanese
The chemistry inside innovation™

FORTRON® 1115L0

Polyphenylene sulfide

Fortron® 1115L0 is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications.

The recommended processing conditions are similar to those of our standard grades, except drying conditions are somewhat milder at 80 to 100 C for 3-4 hours.

Product information

Resin Identification	PPS-GF15		ISO 1043
Part Marking Code	>PPS-GF15<		ISO 11469

Rheological properties

Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.12E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	17400	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2	%	ISO 527-1/-2
Flexural modulus	1.09E6	psi	ISO 178
Flexural strength	29000	psi	ISO 178
Charpy impact strength, 23°C	15.2	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	2.38	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	2.47	ftlb/in²	ISO 180/1A
Ball indentation hardness, H 961/30	32900	psi	ISO 2039-1
Poisson's ratio	0.38		

Thermal properties

Temperature of deflection under load, 1.8 MPa	428	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	239	°F	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.0295	in	IEC 60695-11-10

Electrical properties

Surface resistivity	>1E15	Ohm	IEC 62631-3-2

Physical/Other properties

Water absorption, 2mm	0.02	%	Sim. to ISO 62
Density	0.052	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	626	°F

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Min. melt temperature	590	°F
Max. melt temperature	644	°F
Max. screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	302	°F
Min. mold temperature	284	°F
Max. mold temperature	320	°F
Hold pressure range	4350 - 10200	psi
Back pressure	435	psi

Extrusion

Drying Temperature	212 - 248	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	599	°F
Melt Temperature Range	545 - 608	°F

Automotive

OEM	ADDITIONAL INFORMATION
General Motors	Black; Special Parts Approval, See Your CE Account Representative for Further Details.

Characteristics

Processing	Injection Molding, Extrusion, Blow Molding
Special characteristics	Flame retardant

Additional information

Processing Notes

Pre-Drying

FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< - 30° C. The time between drying and processing should be as short as possible.

Storage

For subsequent storage the material should be stored dry in the dryer until processed (<= 60 h).

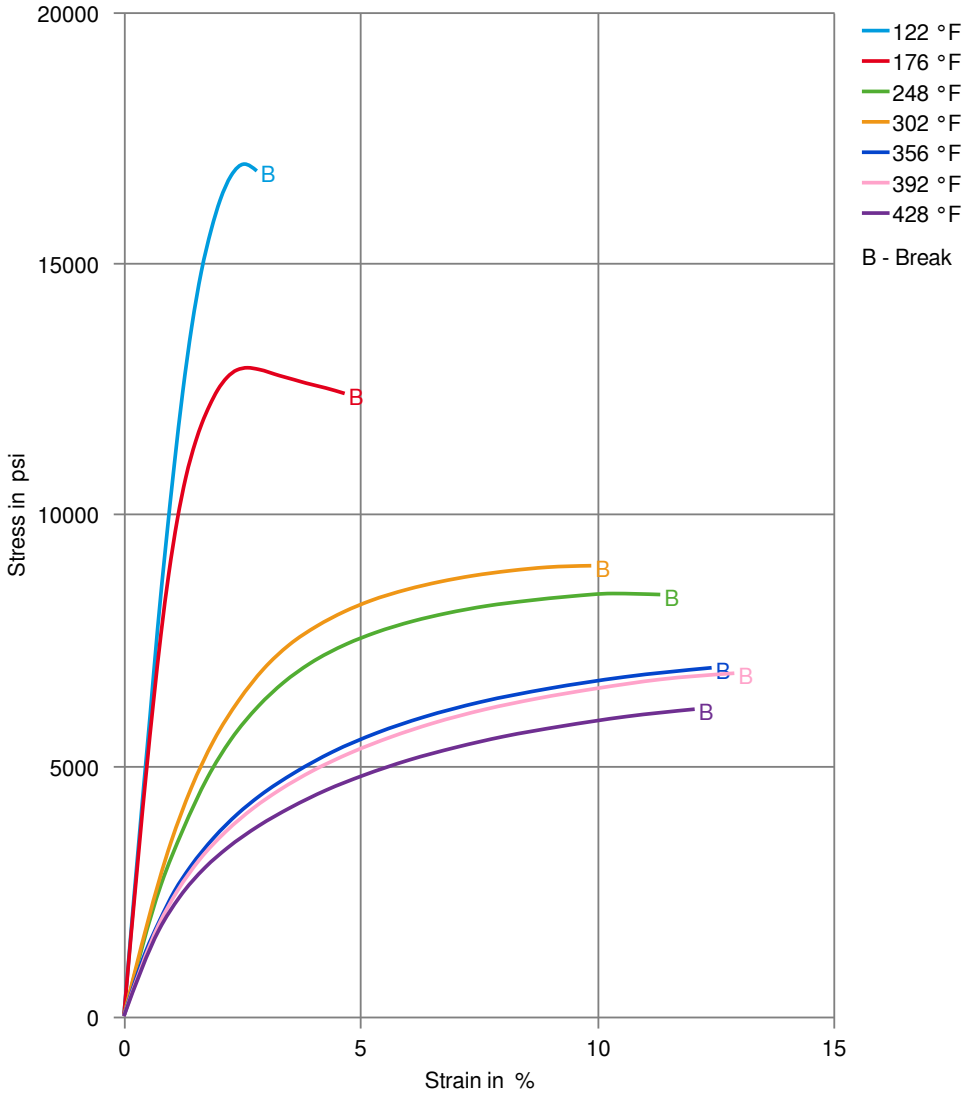
Processing Notes

The higher drying conditions result in higher melt vicosity

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Stress-strain

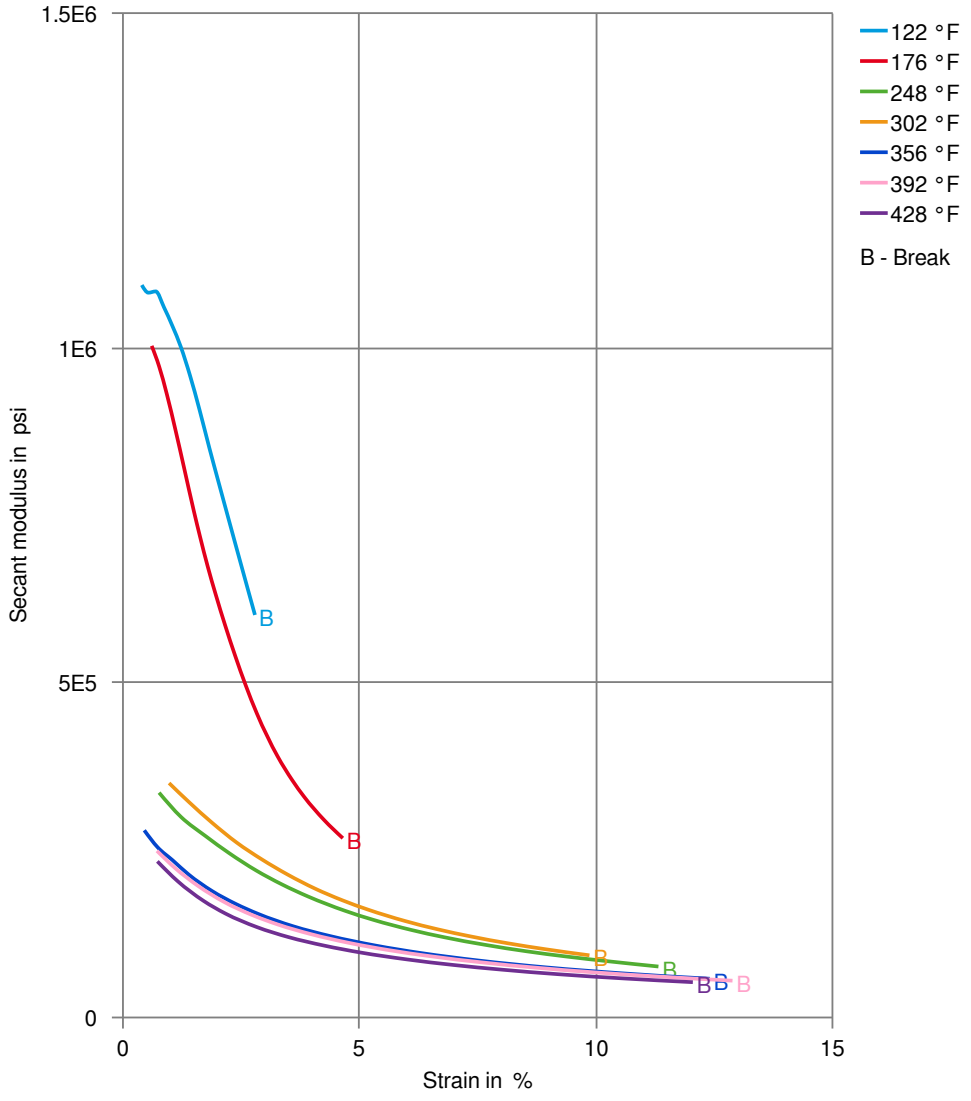


Revised: 2026-09-08 Source: Celanese Materials Database

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Polyphenylene sulfide

Secant modulus-strain



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